

Date: Monday, 29/09/2008 11:54:49 AM
 User: Julie Lecocq

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 42316 *2*
 Estimate Number : 10256
 P.O. Number :
 This Issue : 29/09/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D22303
 First Issue : / / Type : MACHINED PARTS Drawing Number : D2230 REV F
 Previous Run : 41334 Drawing Revision : F
 Written By :
 Checked & Approved By : *300 08.9.29*
 Comment : Est D 00.05.18 Added inspection level 8, and removed P/O for
 powder coat EC

Qty: *Split* ~~200~~ Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)

Lug Extrusion

D2423

Batch: *B39513 43722*

2.0 BAND SAW BAND SAW



Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: *B39513 43722*

cut @ meter

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

RG



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

meter

208/10/02 (200)

4.0 Q02 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Review & inspect for transit damage
 Ensure C of C attached*

5.0 Q05 SECOND CHECK



Comment: SECOND CHECK

inspect level 5

208/12/19 (x54)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 42316

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble and deburr rough edges after tumbling

u/v 08/12/19

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

FL 08/12/19 (53)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/19 (x54)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M 109996

(54X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*1:20
320 °C
1:50*

m-f 08/12/19

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

S 08/12/19 (x54) counter

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *476*

8/12/19

54

12.0 QC21 FINAL INSPECTION/W/O RELEASE



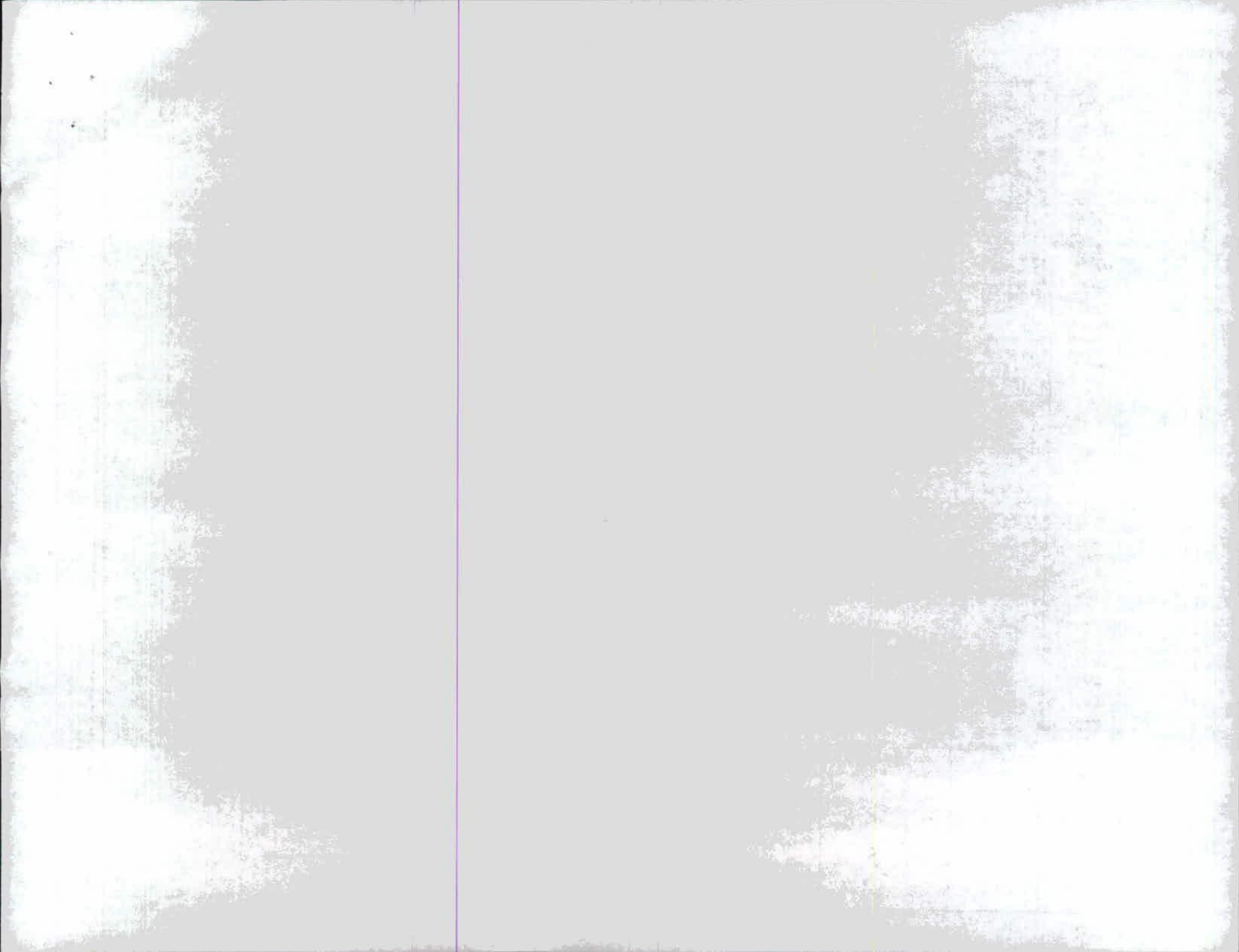
Comment: FINAL INSPECTION/W/O RELEASE

(54) 08/12/19

Job Completion

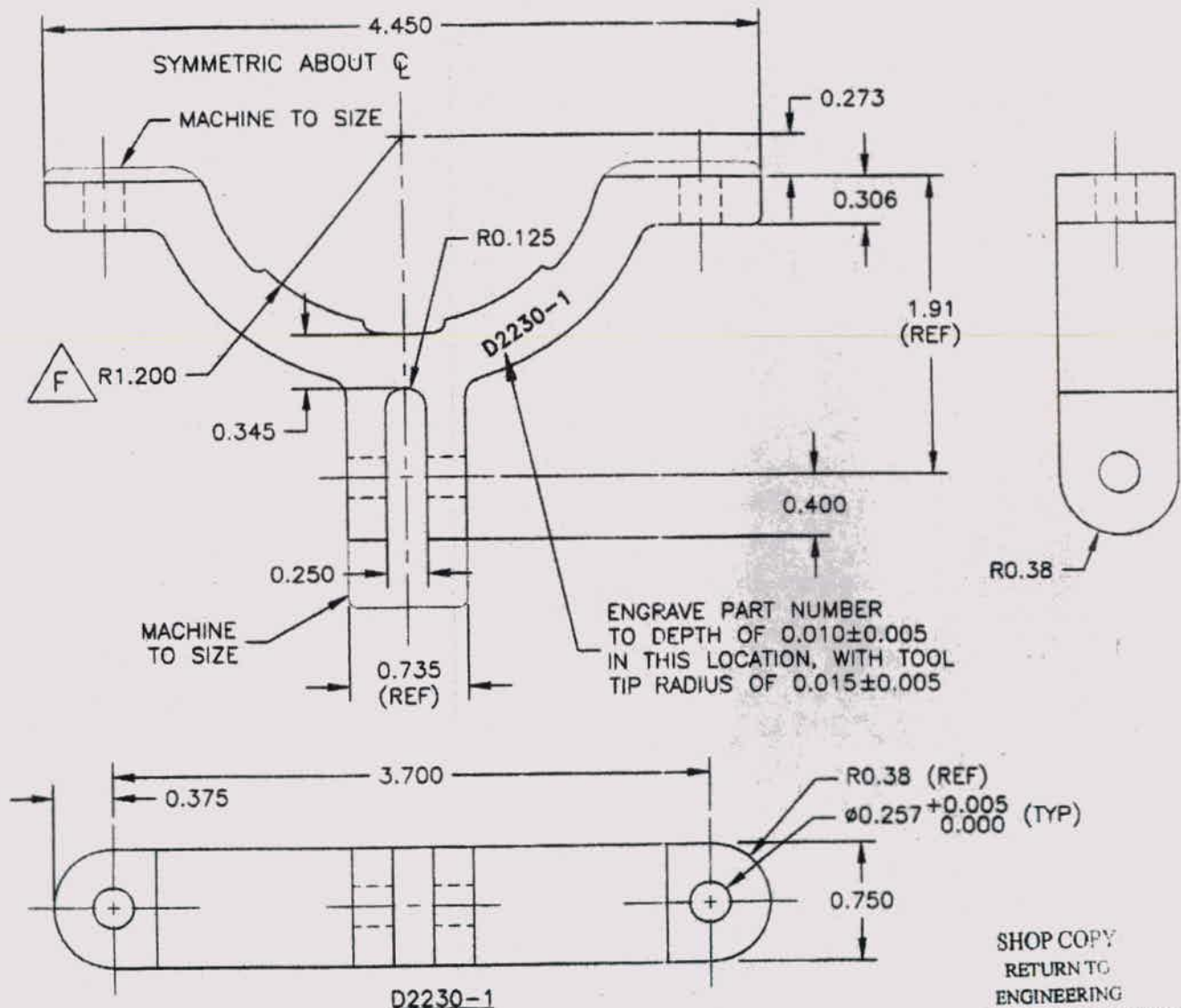


u 08/12/19



DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
-D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN: R1.200 WAS R1.100	

RELEASED
99-12-21 DS

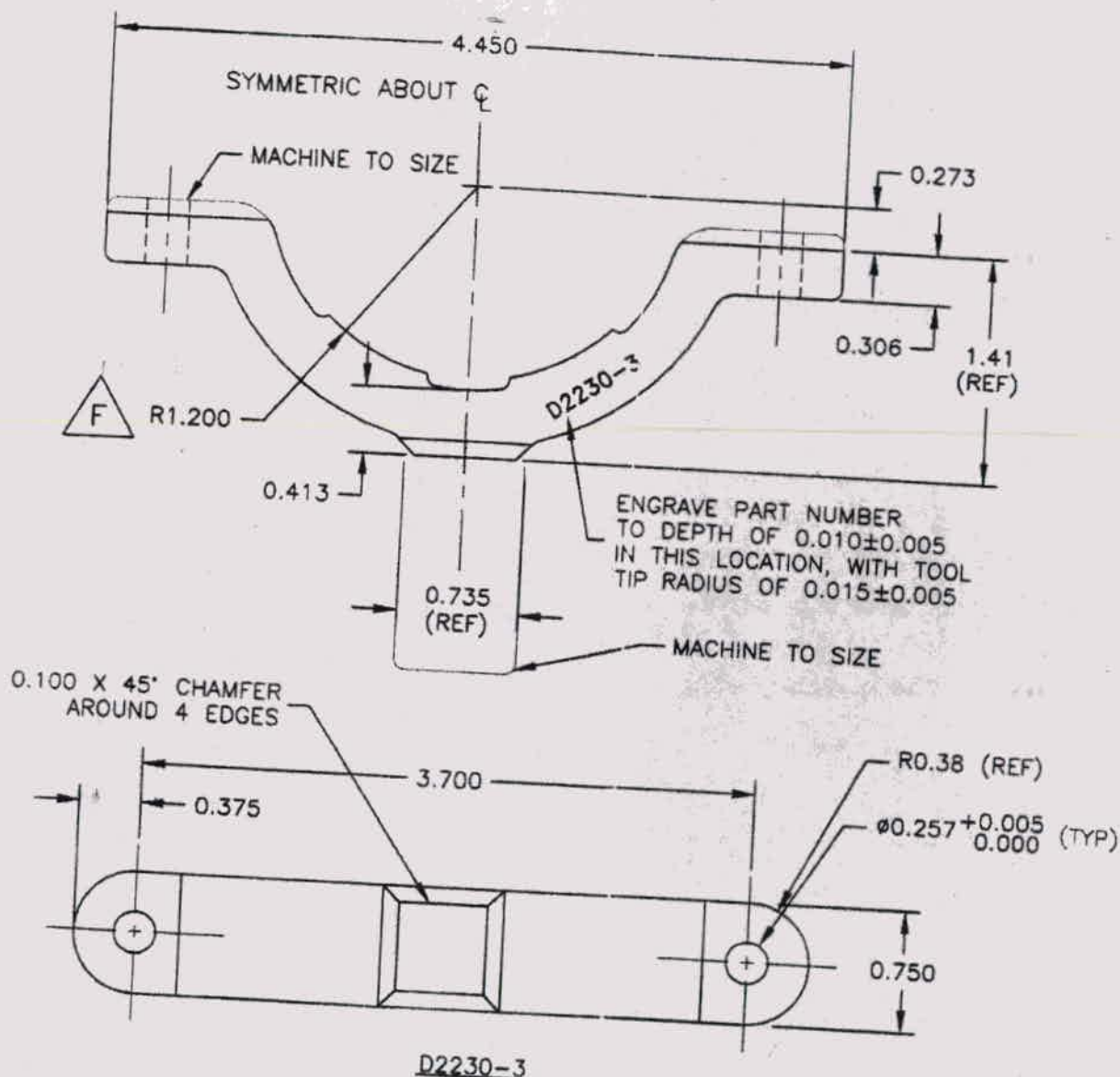
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42316



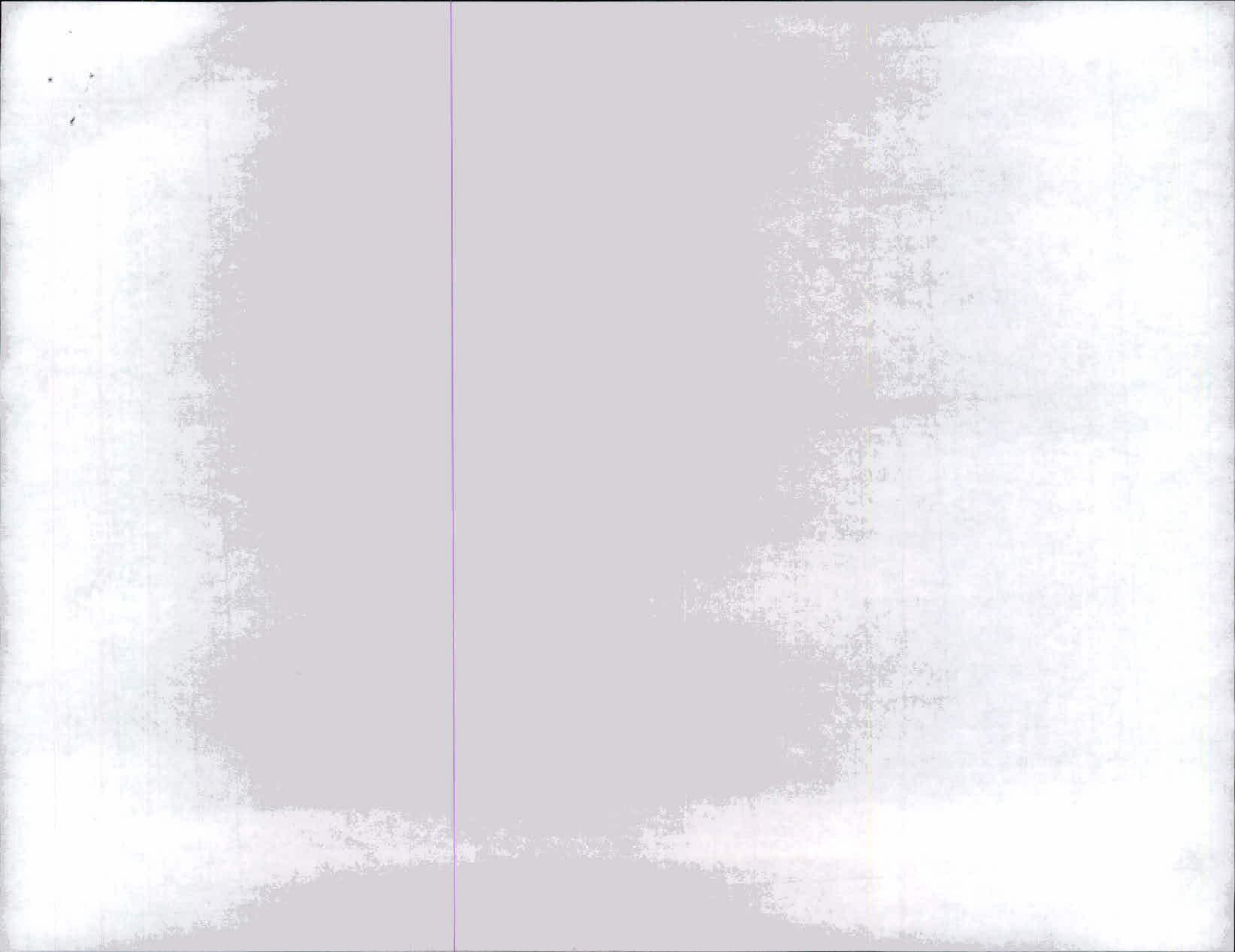
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F
DATE 99.12.13		TITLE MOUNTING LUG	SHEET 2 OF 2
			SCALE 1:1

RELEASED
79.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42300*



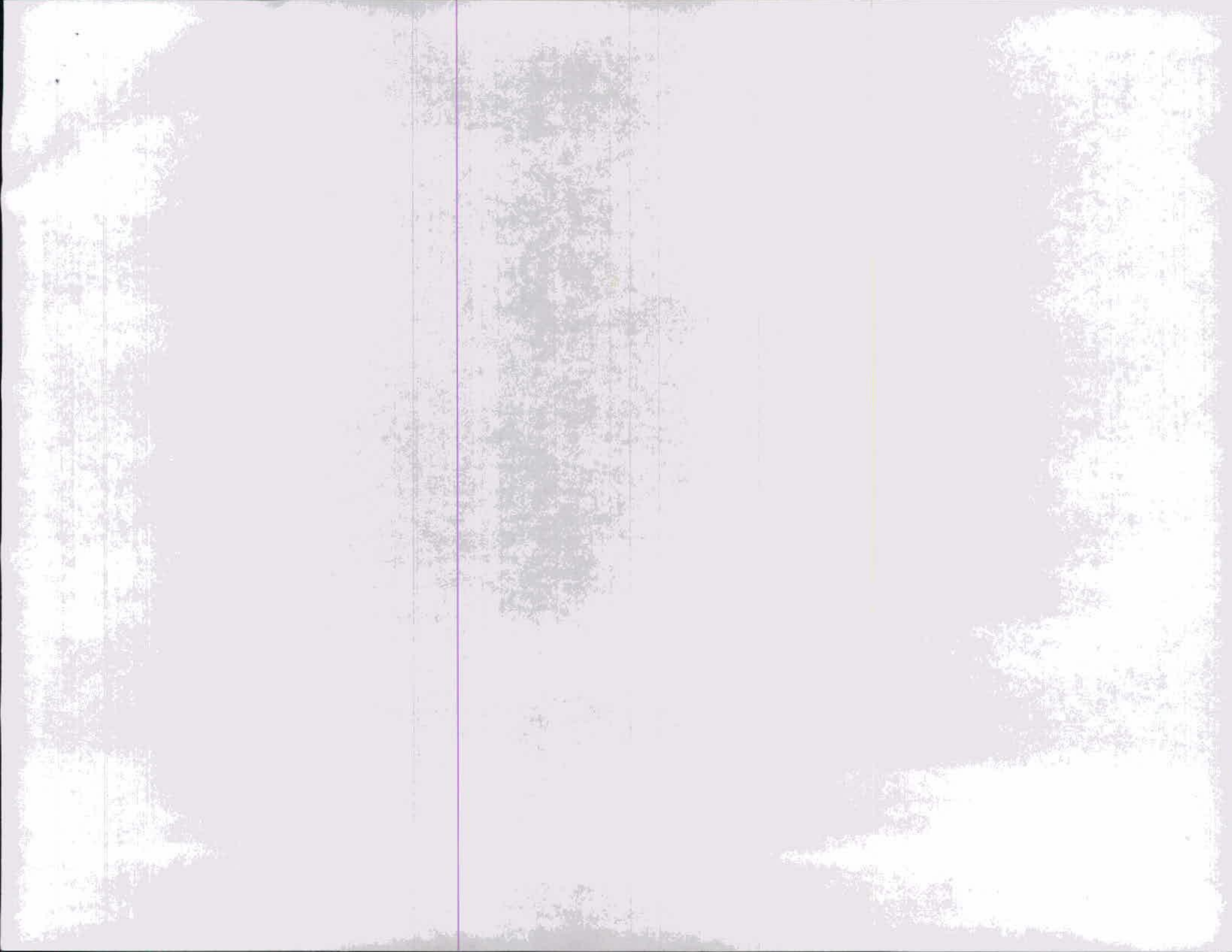


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 16741
Date: Dec 18, 2008
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 7300	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date: Oct 17, 2008

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug Material supplied by DART D2423 B43722	Each	200	54 ✓	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

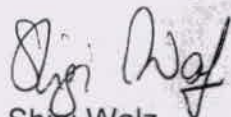
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
54	D2230-3	Mounting lug	7300

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz


08/12/15

Vankleek Hill, December 18, 2008

